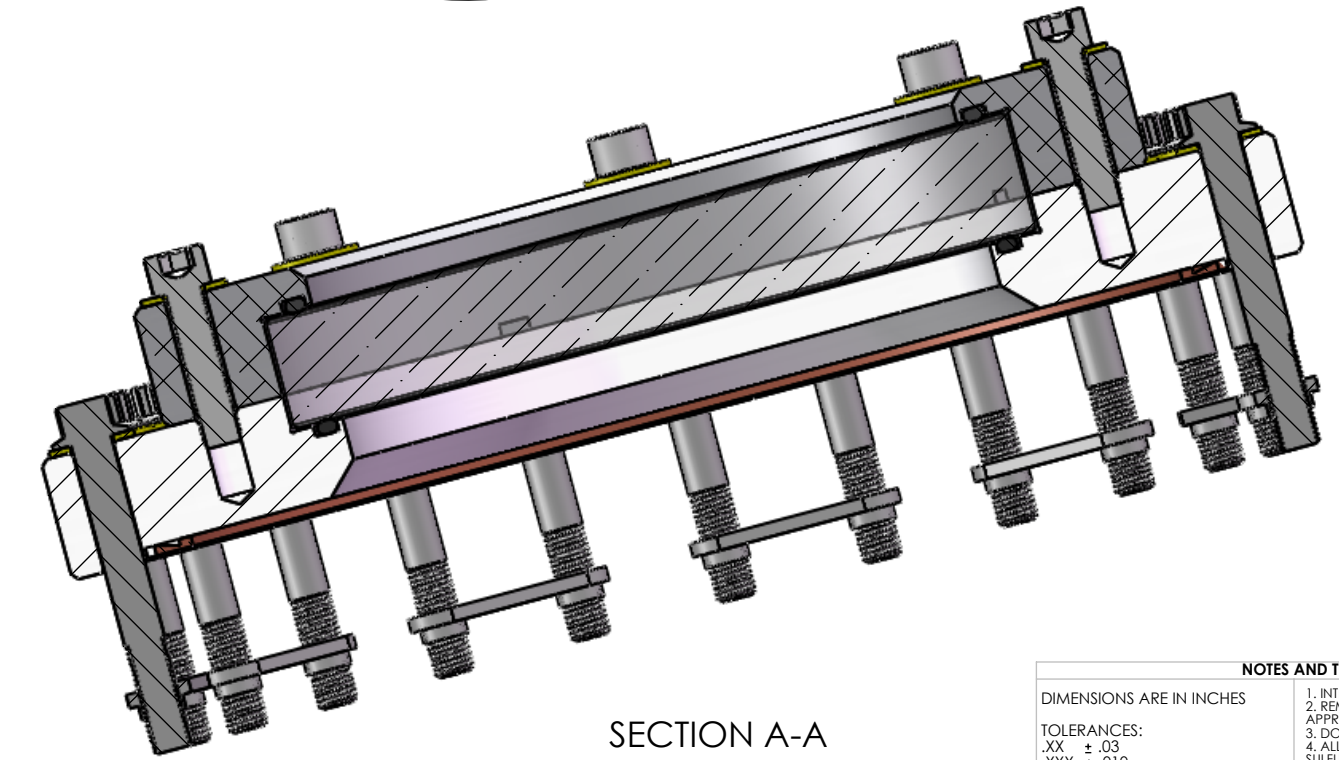
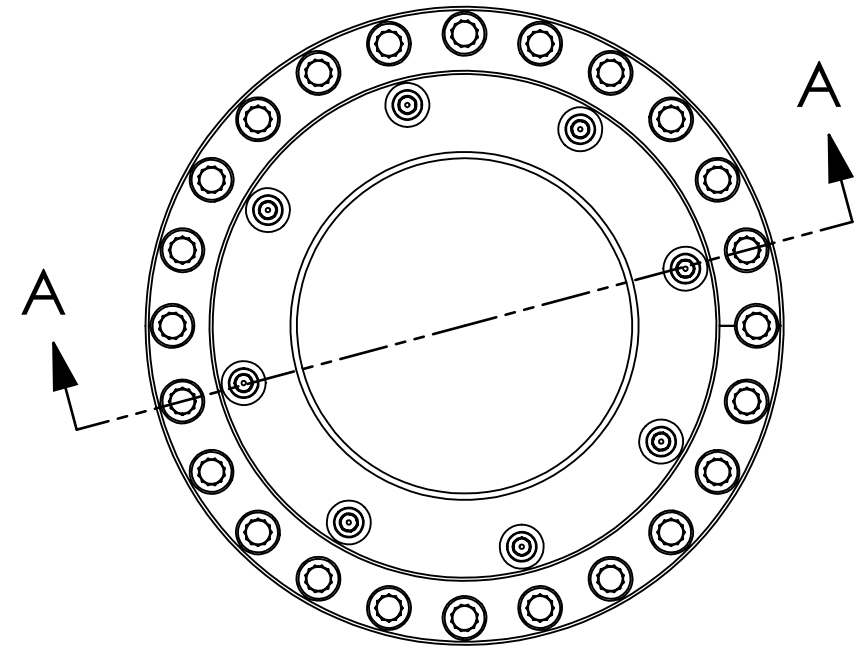
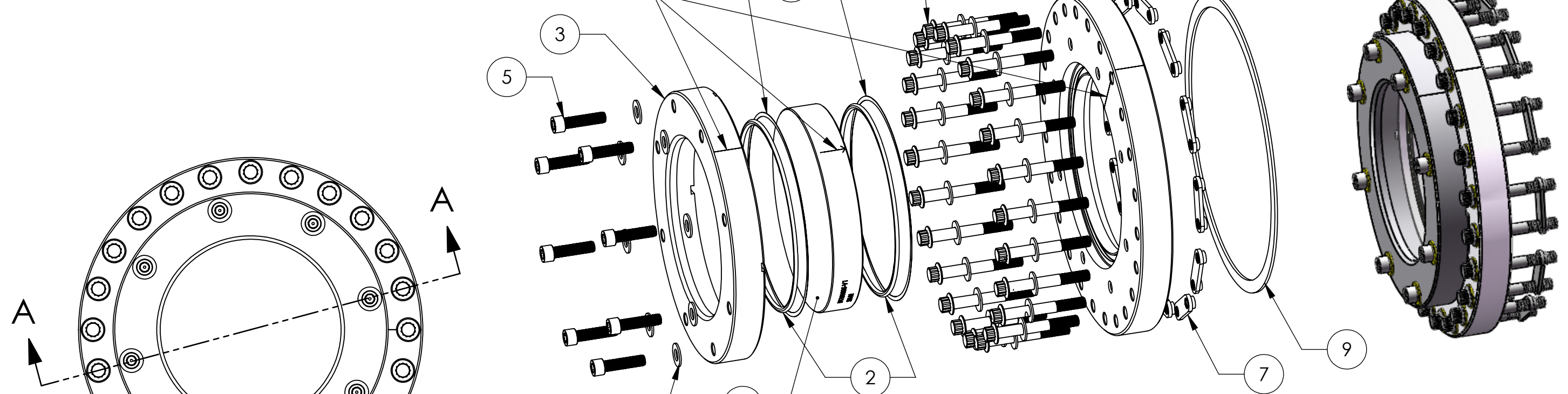


NOTES CONTINUED:
 5. APPROXIMATE WEIGHT = 17 LB.
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484

REV.	DATE	DCN #	DRAWING TREE #
v1	30 MAY 2011	E1100478-x0	E1100479
v2	8 JUL 2011	E1100478-v1	E1100479
v3	23 SEP 2011	E1100478-v4	-

ALIGN MARKS ON FLANGE,
OPTIC AND CLAMP



ITEM NO.	PART NUMBER	QTY.
1	D1101001 aLIGO, high quality, 6in Viewport Flange	1
2	Parker O-Ring #2-253, Viton(R) Fluorocarbon (KFM), 75 Shore A or equivalent. O-Rings must match-must be from the same lot/batch.	2
3	D1101115 aLIGO, high quality, 6in Viewport Clamp, wedged	1
4	D1101005 aLIGO, high quality, wedged, 6in Viewport, Optic	1
5	5/16-24 UNF x 1.25", Silver Plated SS, UC Components #C-3120-NA or equivalent	8
6	5/16" FLAT WASHERS, NAS 1149-C0563R (OR EQUIV.)	8
7	Nut Plate, 10" Conflat, Nor-Cal NP-800 or equivalent	12
8	5/16-24 UNF x 2.5", Silver Plated, 12 PT Flange Bolt and Washers MDC Kit #190067 (qty 25) or equivalent, discard nut.	24
9	Copper Gasket, 10" Conflat, MDC #191019 or equivalent	1
10	D1003207 aLIGO, high quality, 6in Viewport, Viewport Spacer	2

SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .03
 .XXX ± .010
 ANGULAR ± 1.0°
 1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
 MATERIAL N/A FINISH N/A μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		High Quality, Wedged, 6in Viewport Assy	
	SYSTEM AOS	SUB-SYSTEM SLC	DESIGNER Dennis Coyne 30 May 2011	SIZE DWG. NO. B D1101000
DRAFTER Dennis Coyne 30 May 2011	CHECKER Mike Smith 31 May 2011	APPROVAL See DCN	REV. v3	SHEET 1 OF 1

D1101000 aLIGO, high quality, Wedged, 6in Viewport Assy, PART PDM REV: X-007, DRAWING PDM REV: X-005